



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4018-041
Job Sheet 188224



Part No: D4018-041

Job Qty: 1 pcs

Part Name: AS350 Short Basket Lid Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/4/19

Job Tracking No:

Due Date: 1/21/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4020 REV A, D4018 REV E SHEETS 1,2,3 IPP RevA: new issue DD 09.11.30 verified by:EC IPP
Rev:B as per dwg revA 10.03.15 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP
Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP REV:E 13.08.21 DWG REV.D / ECN 13-624 DD
VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier		Sign-off
					Setup Run Hrs Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	1/21/19		0.00 7.69	Large Fab - 1		
						Large Fab - 10		
						Large Fab - 2		
						Large Fab - 3		
						Large Fab - 4		
						Large Fab - 5		
						Large Fab - 6		
						Large Fab - 7		
						Large Fab - 8		
110	QC 9	1 pcs	1/21/19		0.00 0.00	Large Fab - 9		
						QC 9 - 10		
						QC 9 - 18		
						QC 9 - 24		
						QC 9 - 43		
						QC 9 - 50		
120	QC 5	1 pcs	1/21/19		0.00 0.00	QC 9 - 9		
						QC 5 - 10		
						QC 5 - 12		
						QC 5 - 17		
						QC 5 - 18		
						QC 5 - 19		
						QC 5 - 22		
						QC 5 - 24		
						QC 5 - 3		
						QC 5 - 38		
						QC 5 - 42		
						QC 5 - 43		
						QC 5 - 49		
						QC 5 - 51		
						QC 5 - 58		

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
130 Powdercoat - 4 Black Sand	1	1/21/19	0.00 0.42	Powdercoat - 1 - B4B	
-B4B <i>m 138839.</i>	pcs			Powdercoat - 2 - B4B	
<i>START: 8:15 OUT: 3:00 FINISH: 8:45.</i>				Powdercoat - 3 - B4B	<i>BR 19-01-25</i>
				Powdercoat - 4 - B4B	
				Handfinish - 3 - 1 - B4B	
				Handfinish - 3 - 2 - B4B	<i>BEB 19-01-25</i>
140 Handfinish - 3-1- WingWalk-	1	1/21/19	0.00 0.88	Handfinish - 3 - 3 - B4B	
B4B	pcs			Handfinish - 3 - 4 - B4B	
				Handfinish - 3 - 5 - B4B	
150 QC 3	1	1/21/19	0.00 0.00	QC 3 - 10	
	pcs			QC 3 - 13	
				QC 3 - 15	<i>ju 19-1-23</i>
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 26	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 38	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 6	
				QC 3 - 68	
				QC 3 - 9	
160 Packaging 3-1 - Stock - B4B	1	1/21/19	0.00 0.00	Packaging 3 - 1 - B4B	
	pcs			Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	<i>BEB 19-01-25</i>
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	

Entered: _____ Date: _____



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Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		Other/Details:			

				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
170 QC 21 - SA	1	1/21/19	0.00 0.00	QC 21 - SA - 21	DAE
	pcs			QC 21 - SA - 70	21

JAN 20 2019

Part Op 100 - (Weld per dwg A/R S.S. rod Batch: _____) 1- assemble ribs , weld as per dwg D4018 using DT9607B 2- weld Descriptions: hinge (3) and Mounting brackets as per dwg D4018 ***inspect before welding mesh*** 3- Cut mesh as per dwg D4020-7 4- tack weld mesh on basket as per dwg D4018 ***make sure to place mesh correctly on lid, check with label plate before tacking mesh***

110 - (QC9- Inspect visual per QSI004- Fusion Welds)

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) *** mask sides of hinge prior to powdercoat***

140 - (Wing Walk as per dwg QSI005 4.4 Batch 4158963) 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg Install placard and label as per dwg

150 - (QC3- Inspect Part Finish)

160 - (Identify as per dwg & Stock Location: _____)

170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581 ✓	Mounting Bracket	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	5143339
D4016-3 ✓	Hinge Half, Lid	3 pcs (3 ea) ✓	100-Large Fab - Basket - 1	5110937
D4018-1 ✓	Rib	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	1x5 111234 / 1x5 117158
D4018-3 ✓	Rib	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	5111293
D4018-5 ✓	Rib	6 pcs (6 ea) ✓	100-Large Fab - Basket - 1	5143334
D4021-3 ✓	Data Plate ✓	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	5114284
D4035-043 ✓	Lid Rib Assembly, Aft (350 Basket)	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	51403614
M304EX0.75-16F	Expanded Metal Flat SS	16 sf (16 ea)	100-Large Fab - Basket - 1	5125258

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581 ✓	2	15	0
	D4016-3	3	185	0
	D4018-1	2	14	0
	D4018-3	2	14	0
	D4018-5	6	18	0
	D4021-3	1	12	0
	D4035-043	2	4	0
	M304EX0.75-16F	16	1,500	0

Part Specifications

Specification

DART
AEROSPACE

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S147520



Part: D4018 - 041

Job No: 188224

Serial No/Batch: S147520

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 01/24/19

Entered: _____ Date: _____



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